



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB T101577-1-PO
Job Sheet 184491



Part No: RB T101577-1-PO

Job Qty: 1 ea

Part Name: Staking Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/10/18

Job Tracking No:

Due Date: 10/12/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RB T101577-1 Rev.0 IPP Rev. 3 18.10.10 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs	10/12/18	10/12/18	0.00	0.00	Purchasing		<i>[Signature]</i> OCT 11 2018
110	Packaging	1 pcs	10/12/18	10/12/18	0.00	0.00	Packaging2		<i>[Signature]</i> OCT 11 2018
120	QC	1 pcs	10/12/18	10/12/18	0.00	0.00	QC6		<i>[Signature]</i> 38
130	Small Fab	1 pcs	10/12/18	10/12/18	0.00	0.10	Small Fab-2		<i>[Signature]</i> 9-89 DAS
140	QC	1 pcs	10/12/18	10/12/18	0.00	0.00	QC5		<i>[Signature]</i> 38
150	Packaging	1 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3		<i>[Signature]</i> 9-89
160	QC21-FG	1 Ea	10/12/18	10/12/18	0.00	0.00	QC21		<i>[Signature]</i> 21 OCT 16 2018

Part Op 100 - Issue P/O: 041285 MANUFACTURE RB RB T101577-1 AS PER DWG Supplier: AIRCRAFT HARDWARE
Descriptions: ACCESS -Certificate of conformity is required

130 - Re-identify as required.

150 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

Oct 2018 x 1 [Signature]

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB T101577-1P	Staking Tool	1 pcs (1 ea)	100-Purchasing	5117425

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB T101577-1P	1	0	0

Part Specifications

Dart Aerospace Ltd. could not be found.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Plex 10/10/18 1:58 PM dart.Lussier.Patrick



Container No: S117426



Part: RB T101577-1

Job No: 184491

Serial No/Batch: S117426

Revision: 0

Inspector:

Exp Date:

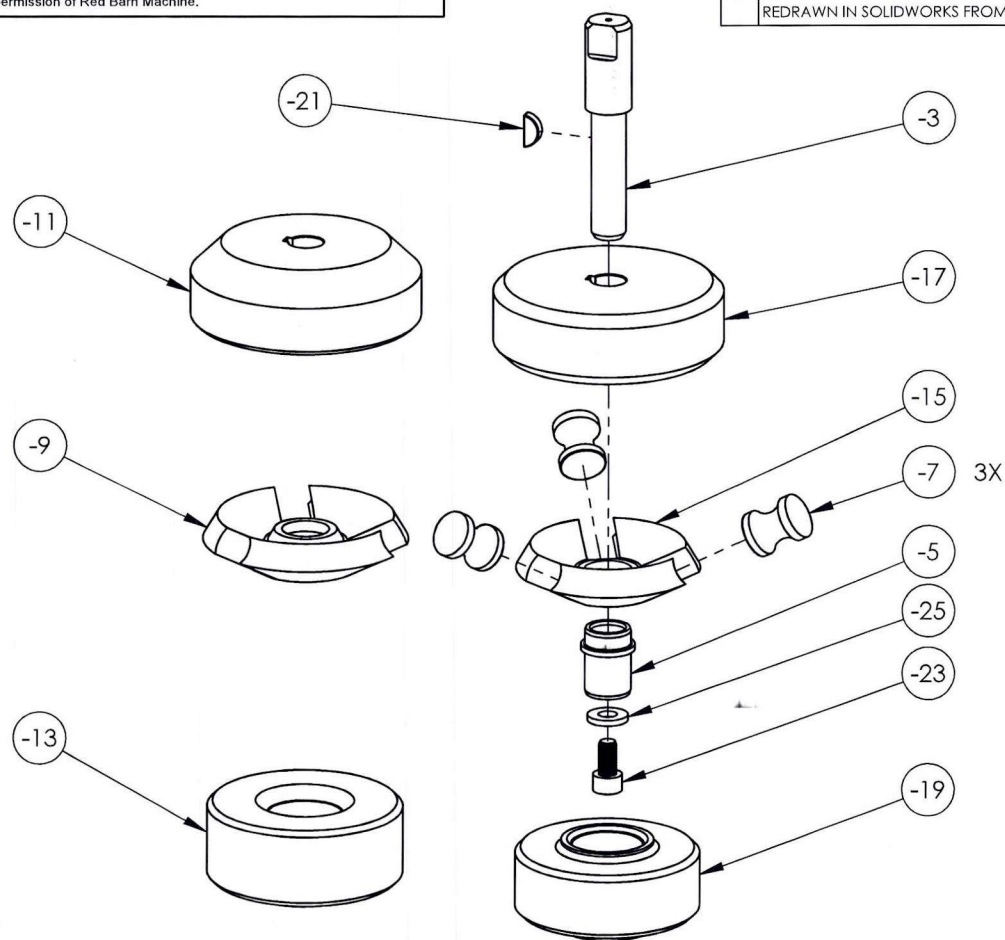
Instructions:

Date: 10/11/18

exus_Control/Report_View_2.asp?URL=https://www.plexonline.com/22... 1/1

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
	REDRAWN IN SOLIDWORKS FROM TATTERED ORIGINAL DWG.	8/30/2013	CFS



NOTE:

1. USED ON MODEL: BELL 205A1, 212, 214B, 222, 222B, 222U, 230, 407, 412, & 430.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-3	1	ARBOR	01	Ø5/8 X 2-3/4	2
			-5	1	BUSHING	ALUM. BRONZE	Ø5/8 X 1	3
			-7	3	ROLLER	01	Ø5/8 X 3/4	4
			-9	1	RETAINER	ALUM. BRONZE	Ø2-1/2 X 1	5
			-11	1	HOUSING	01	Ø2-5/8 X 1-1/4	6
			-13	1	BACK STOP	4140 Q&T	Ø2-1/4 X 1-1/4	7
			-15	1	RETAINER	ALUM. BRONZE	Ø2-1/2 X 1	8
			-17	1	HOUSING	01	Ø2-5/8 X 1	9
			-19	1	BACK STOP	4140 Q&T	Ø2-1/4 X 1-1/4	10
		B/O	-21	1	WOODRUFF KEY	STEEL	#213 WOODRUFF KEY MCMaster-CARR #98525A075	1
		B/O	-23	1	SOCKET HEAD CAP SCREW	S.S.	#10-32 X 3/8 MCMaster-CARR #92200A340	1
		B/O	-25	1	FLAT WASHER	STEEL	Ø.438 X .063 AIRCRAFT SPRUCE #AN960-10	1



RED BARN MACHINE

TITLE STAKING TOOL, TAIL ROTOR YOKE
FLAP & PITCH CHG BRGS

DWG NO.

RB T101577-1

REV

MAT'L

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

.XXX ± .010 FRACTIONS ± 1/32
.XX ± .03
.X ± .1 ANGLES ± 5°

1. BREAK ALL SHARP EDGES .015 x 45°
OR .015R
2. DIMENSIONAL LIMITS APPLY AFTER
PLATING

DRAWN BY: SMITH

APPROVED

D Weil

HEAT

TREAT

FINISH

SPEC

USED ON MODEL

SEE NOTE

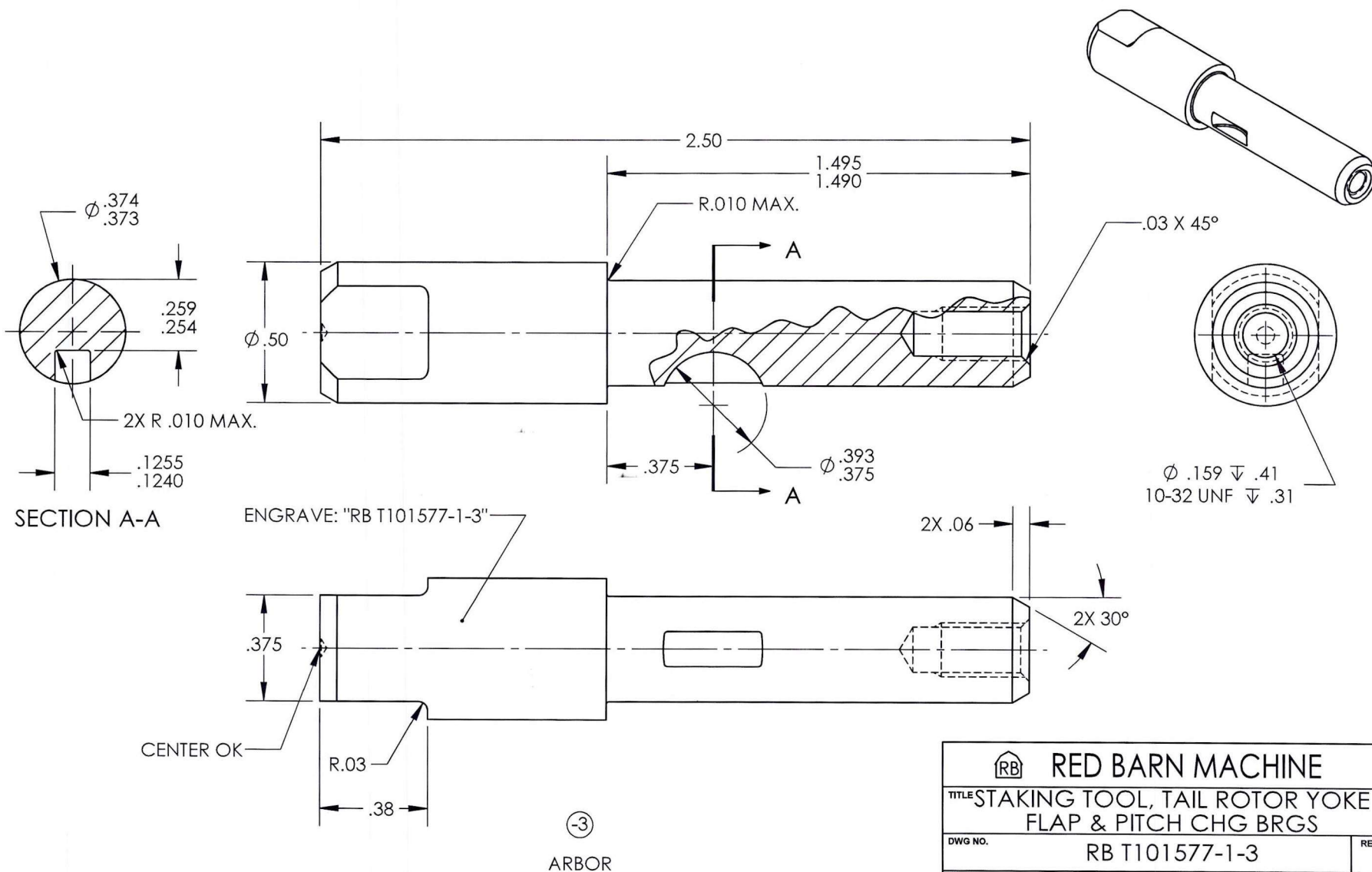
SCALE 1:2

DATE 8/26/2013

SHEET 1 OF 10

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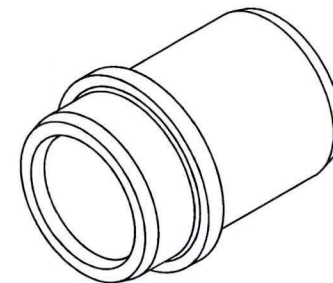
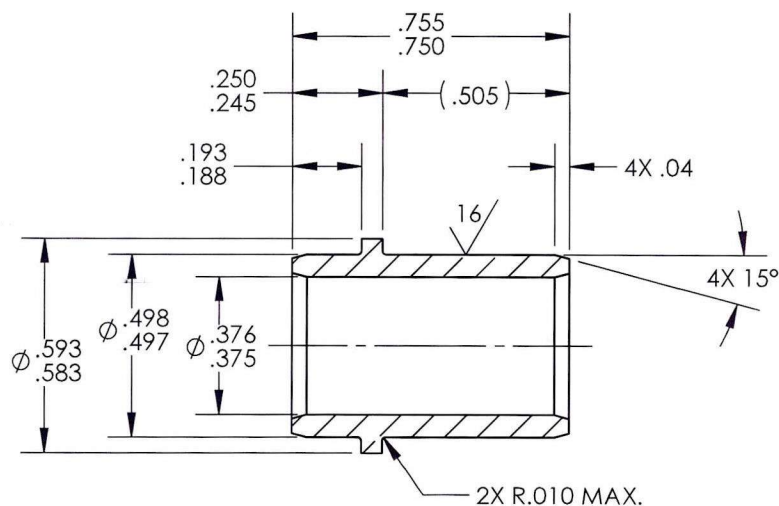
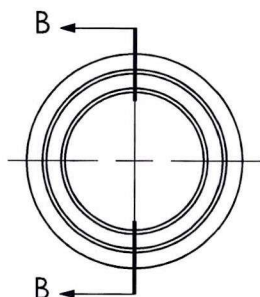
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



RED BARN MACHINE	
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO. RB T101577-1-3	REV
MAT'L 01	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010	HEAT TREAT RC 58-62
.XX ± .03	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 8/26/2013
SHEET 2 OF 10	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



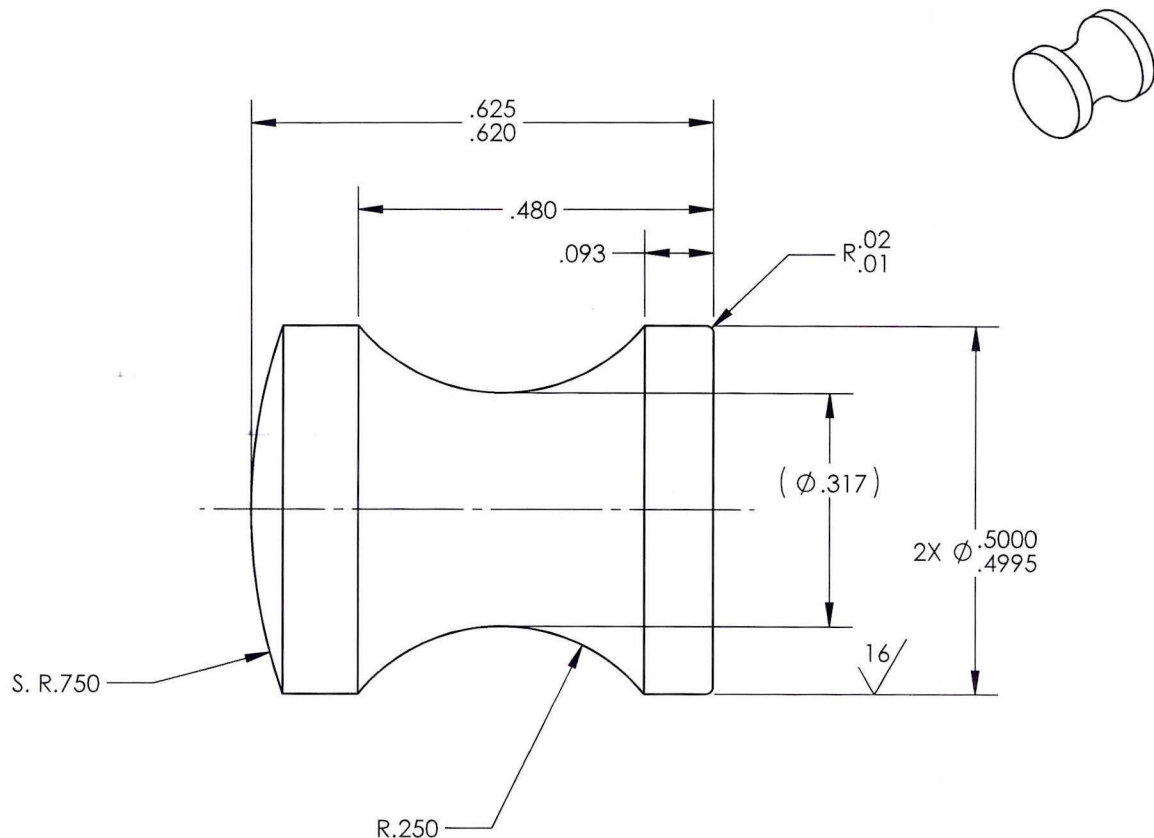
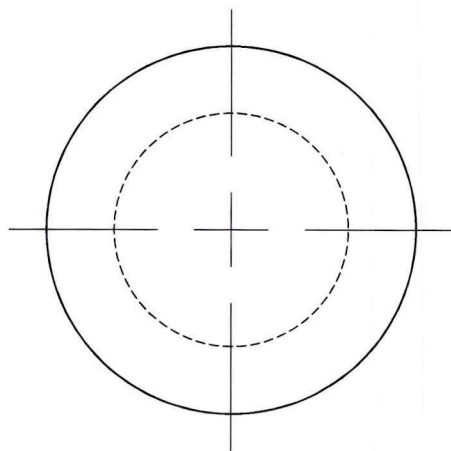
SECTION B-B

(-5)
BUSHING

RED BARN MACHINE	
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	RB T101577-1-5
REV	
MAT'L ALUM. BRONZE	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010	HEAT TREAT
.XX ± .03	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 8/26/2013
SHEET 3 OF 10	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL

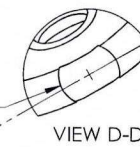
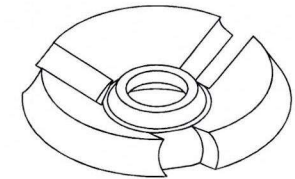
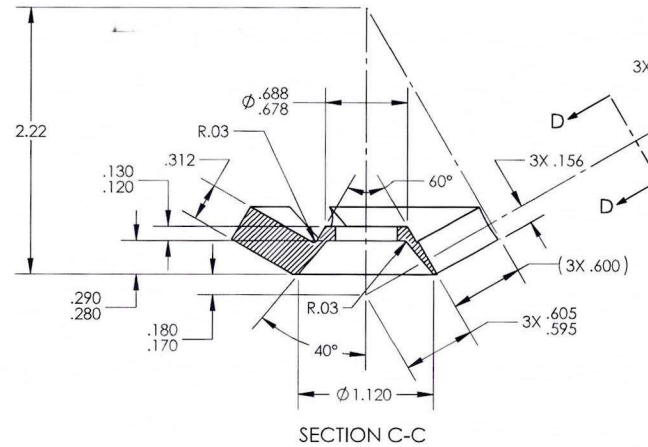
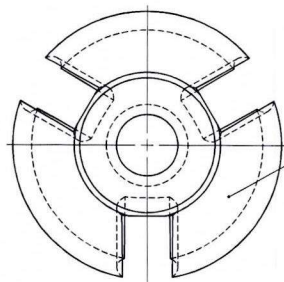
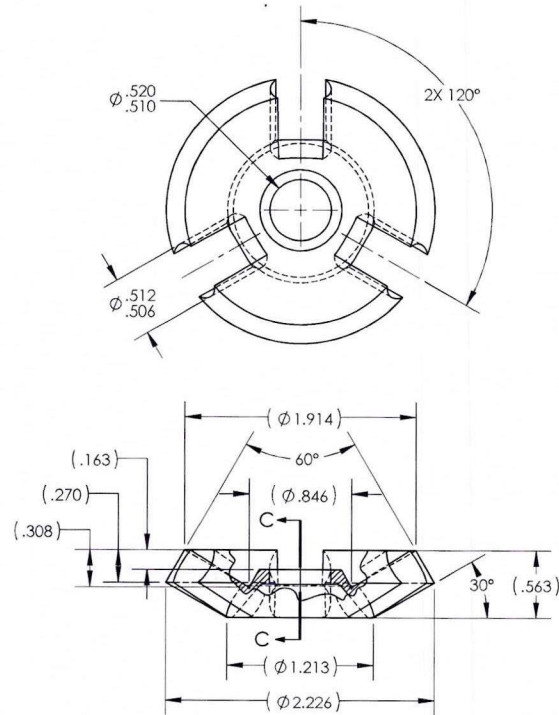


(-7)
ROLLER

RED BARN MACHINE	
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO. RB T101577-1-7	REV
MAT'L 01	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/32 .XX ± .03 ANGLES ± .5° .X ± .1	APPROVED <i>D Weil</i> HEAT TREAT RC 58-62 FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 2:1	DATE 8/26/2013 SHEET 4 OF 10

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REV	DESCRIPTION	REVISIONS		
		DATE	INITIAL	APPROVED

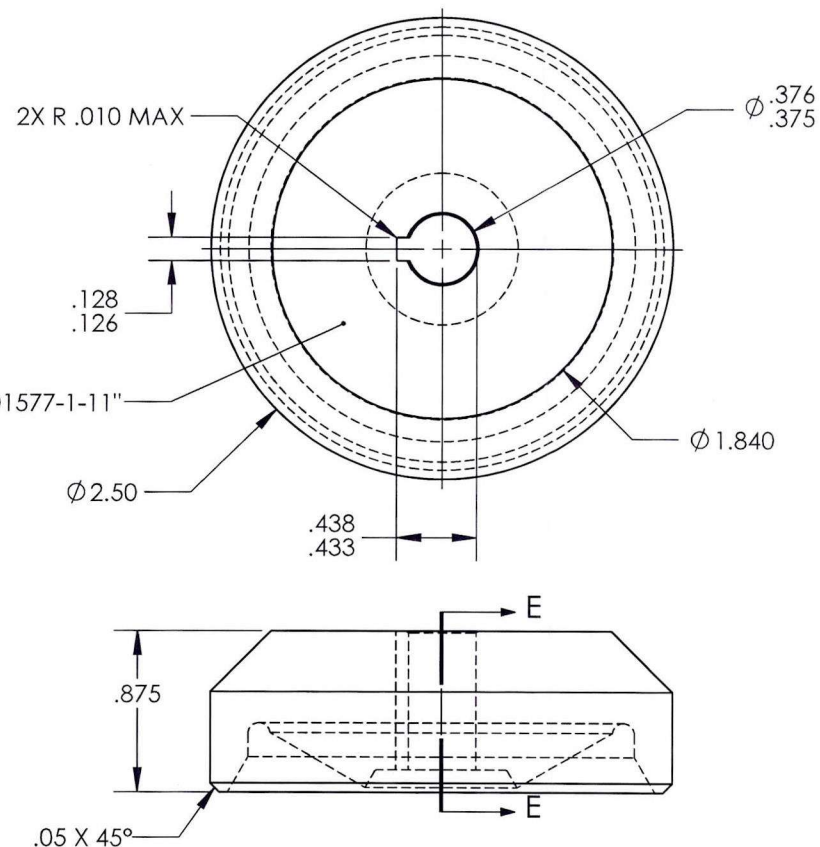
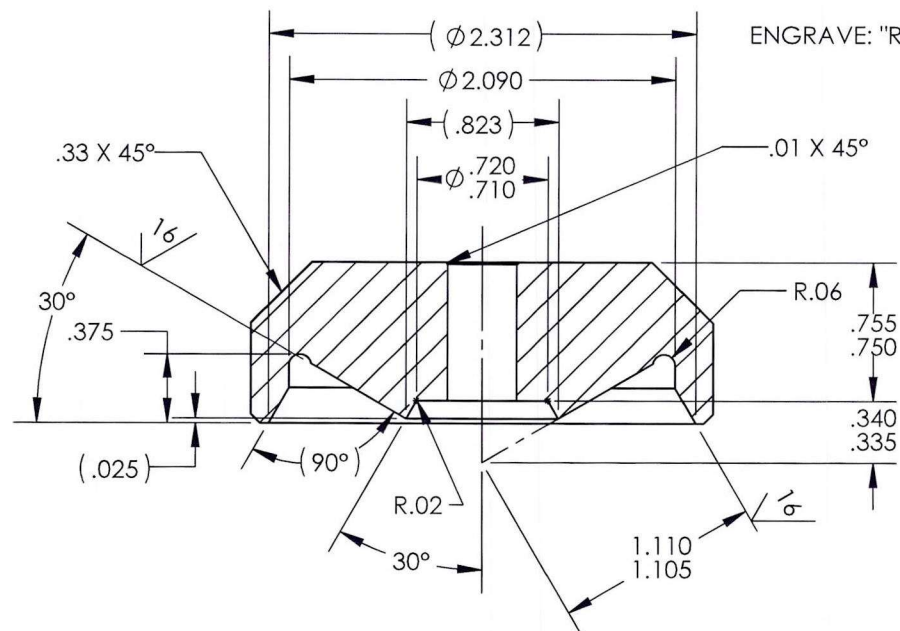


RETAINER

RED BARN MACHINE	
TITLE: STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO. RB T101577-1-9	
MAT'L ALUM. BRONZE	
DRAWN BY: SMITH	
UNLESS OTHERWISE SPECIFIED	
APPROVED: D. Med	
DIMENSIONS ARE IN INCHES	
REAT	
FINISH	
SPEC	
1. BREAK ALL SHARP EDGES .015 x 45°	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	
SCALE 1:1	DATE 8/26/2013
SHEET 5 OF 10	

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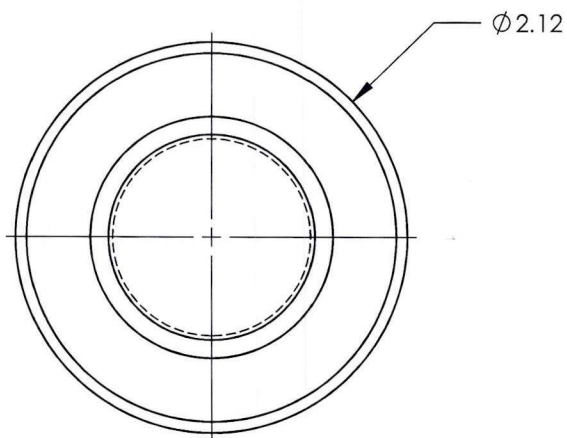
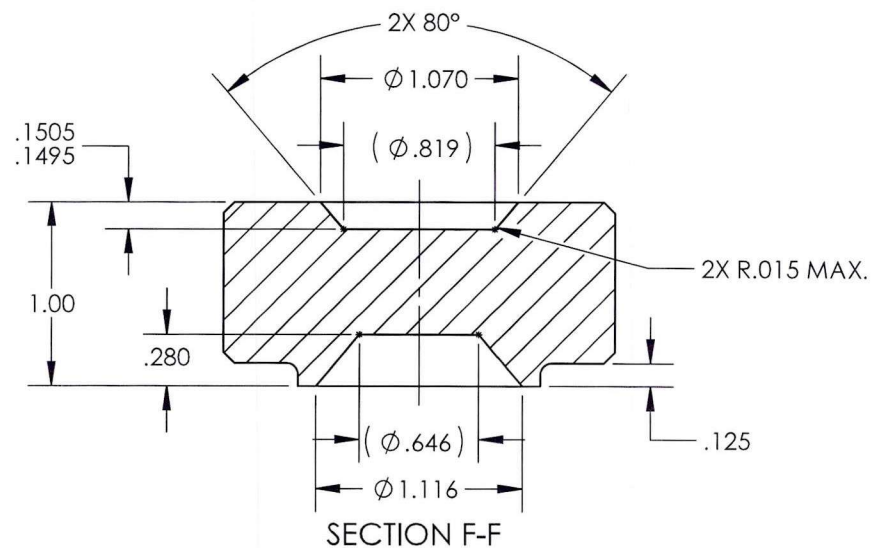
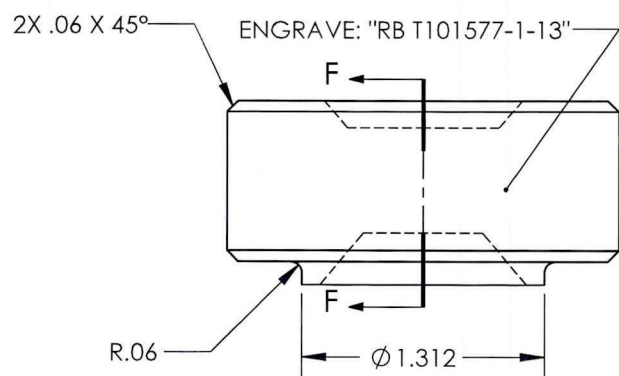
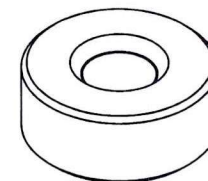
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



RED BARN MACHINE	
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	RB T101577-1-11
MAT'L 01	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010	FRACTIONS ± 1/32
.XX ± .03	ANGLES ± 5°
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/26/2013
SHEET 6 OF 10	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED

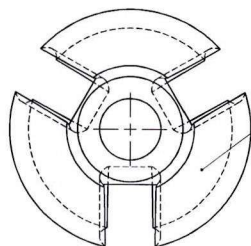
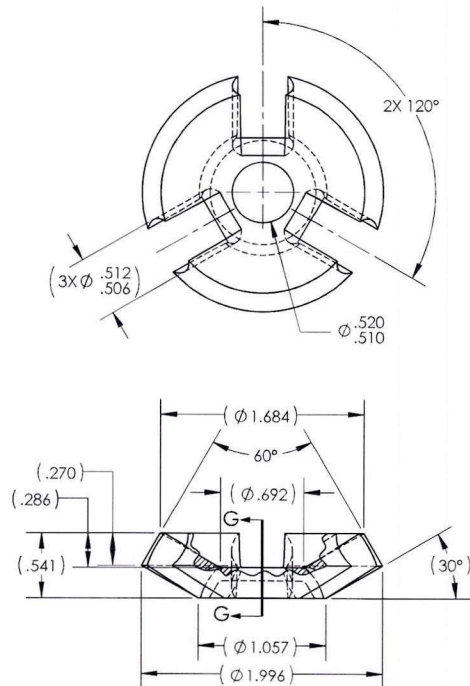


(-13)
BACK STOP

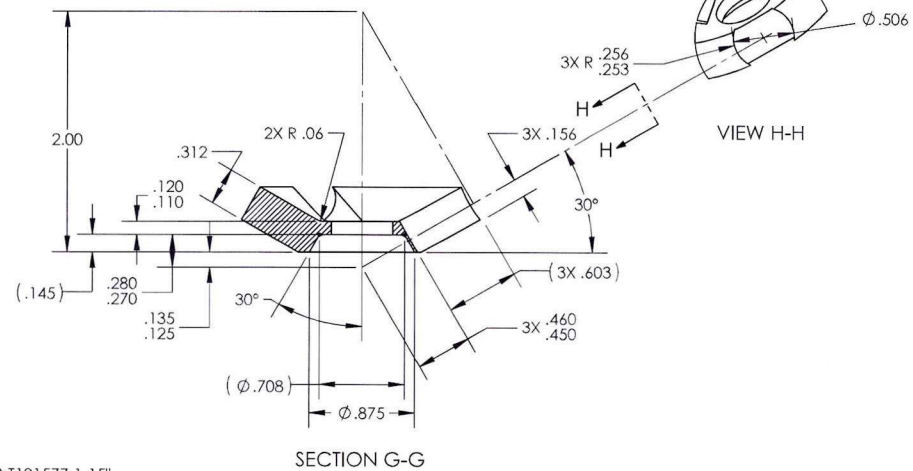
RED BARN MACHINE	
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO. RB T101577-1-13	REV
MAT'L 4140 Q&T	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .03 ANGLES ± 5°	FINISH BLACK OXIDE
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/26/2013 SHEET 7 OF 10

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



ENGRAVE: "RB T101577-1-15"

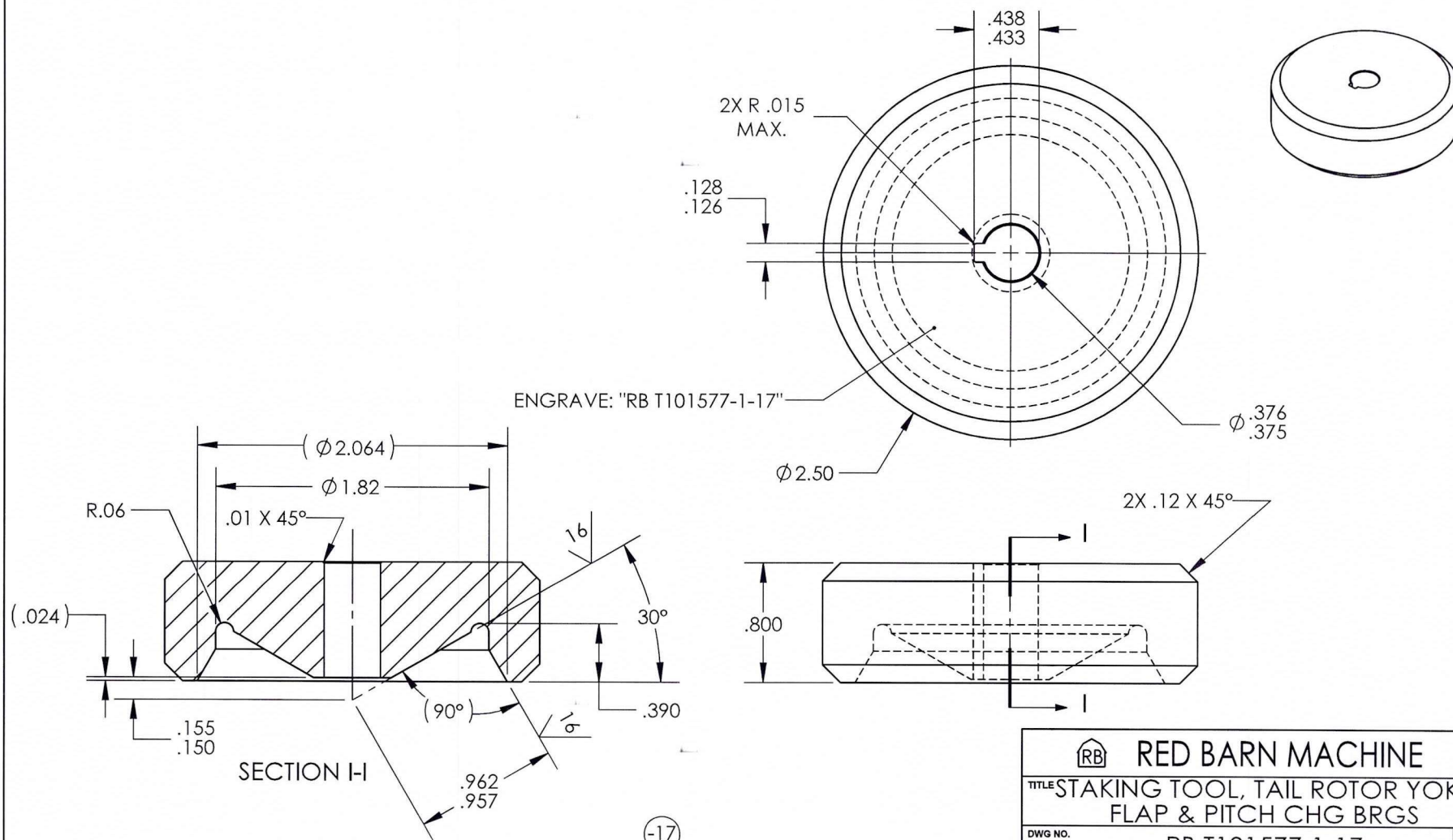


(-15)
RETAINER

RED BARN MACHINE	
TITLE: STAKING TOOL, TAIL ROTOR YOK FLAP & PITCH CHG BRGS	
DWG NO. RB T101577-1-15	
MAT'L ALUM. BRONZE	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/32 .XX ± .03 .X ± .1	APPROVED: <i>D. Med</i> DATE: 8/26/2013
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC: USED ON MODEL
SCALE 1:1	SHEET 8 OF 10

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



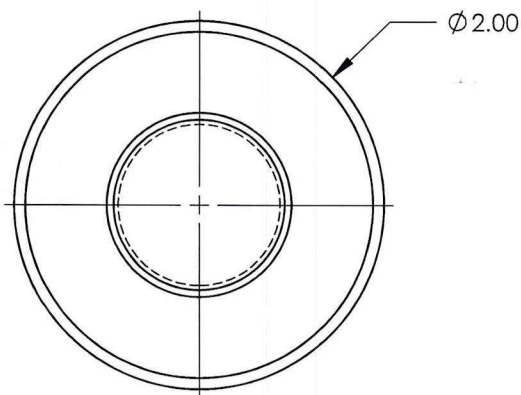
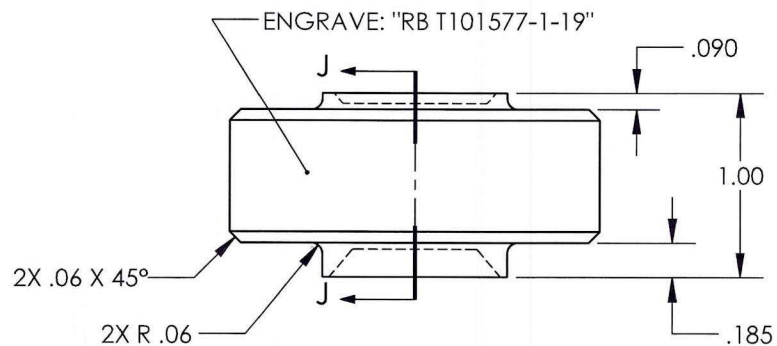
(-17)

HOUSING

RED BARN MACHINE	
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO.	REV
RB T101577-1-17	
MAT'L 01	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010	FRACTIONS ± 1/32
.XX ± .03	ANGLES ± .5°
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/26/2013
SHEET 9 OF 10	

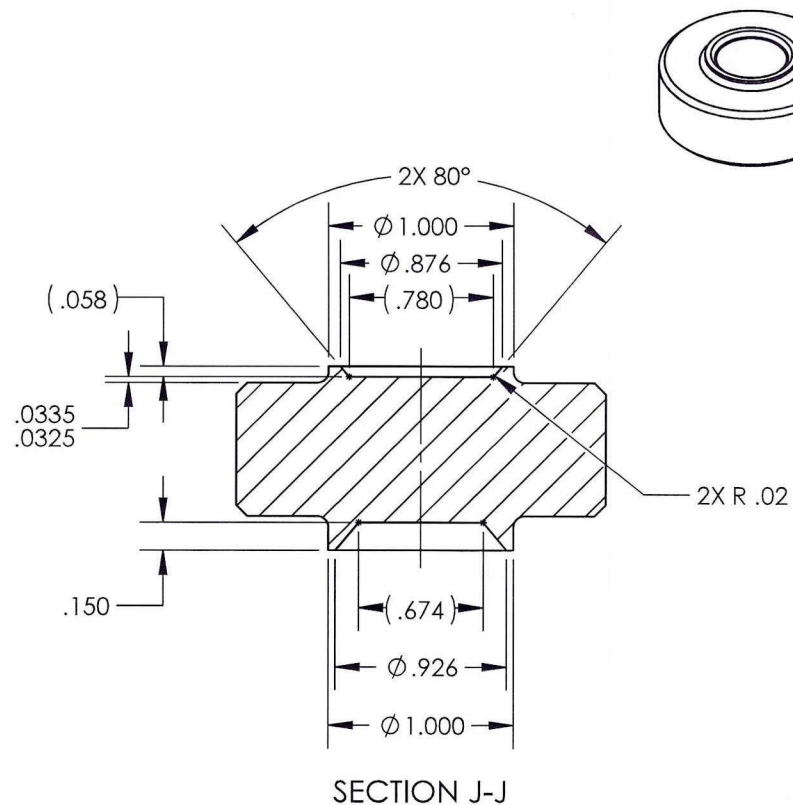
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



(-19)

BACK STOP



SECTION J-J

RED BARN MACHINE	
TITLE STAKING TOOL, TAIL ROTOR YOKE FLAP & PITCH CHG BRGS	
DWG NO. RB T101577-1-19	REV
MAT'L 4140 Q&T	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX $\pm .010$	HEAT TREAT
.XX $\pm .03$	FINISH BLACK OXIDE
.X $\pm .1$	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 8/26/2013
SHEET 10 OF 10	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ORDER ACKNOWLEDGEMENT

CUSTOMER

Customer Code: CSERV03

Sold To: Servicios Aereos De Los Andes
Ave. Republica de Colombia 791, 9th Floor, San
Isidro

Lima
Peru
Phone: +51 (1) 200 2700

Ship To: Servicios Aereos De Los Andes
Ave. Republica de Colombia 791, 9th Floor, San
Isidro

Lima
Peru
Phone: +51(1) 200 2700

ORDER

Order No : 7854

Date: 7/5/18

Ship-To Contact: Mario E Chirichigno Mena

Email: mchirichigno@losandescorp.com

Cust PO No: 14623

FOB: Shipping Point

Ship Via: See comments below

Freight Terms: PrePaid

Terms: Prepay

INCO Terms: Ex Works

Order Taker: Oscar Martinez

Order Taker Phone:

Order Taker Email: omartinez@dartaero.com

Line No	Due Date	Ship Date	Part	Description/Note	Quantity	Unit	Price	Unit	Extended Price
1	10/16/18	10/16/18	RB T101577-1	Staking Tool LT 3-4 DAYS ARO	1	pcs	\$3,059.00USD	pcs	\$3,059.00 USD
Sub Total									\$3,059.00 USD
Grand Total									\$3,059.00 USD

ORDER NOTES

CUSTOMER PO 14623

*** AOG ***

End User:
Servicios Aereos de los Andes

For shipping instructions please contact Mario Chirichigno at +51(1)200 2700/2732 . In my last conversation with him he mentioned they will be picking up the order.

All Prices Quoted In USD & Valid For 30 Days. All Parts Subject To Prior Sale & Are Ex-Works Manufacturing Facility In Hawkesbury, ON, Canada

Remit to: DART Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario K6A 1K7 Canada

Tel: 613 632 5200

Fax: 613 632 5246

accounting@dartaero.com

GST/HST 10127 2607

Note: A minimum 15% restocking fee is applicable. Custom items are non-refundable. Full warranty details are available at www.dartaerospace.com

Latest Revision Provided Unless Otherwise Requested

Plex 10/9/18 1:24 PM dart.martinez.oscar



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041285**

Supplier: AIH001-VU
Aircraft Hardware and Accessories
P.O. Box 14007
Ft Worth, TX 76617 USA
Phone: 817 680 3523
Fax: 817 838 9111

PO No: PO041285
PO Date: 10/9/18
Due Date: 10/12/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Fedex P1 Overnight
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	184491	RB T101577- 1P		Staking Tool	Firmed	-	10/12/18	1 pcs	0 pcs	1 pcs	\$1,000.00/pcs	\$1,000.00

DAS
38
9-89

Line Item Note ship fedex p1 acc # 1-5173924-0

Grand Total: \$1,000.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 10/9/18 4:21 PM dart.Lussier.Patrick

AIRCRAFT HARDWARE & ACCES.
P.O. BOX 14007 FT. WORTH TX 76117
Phone: 817-680-3523 FAX- 817-416-5274
e-mail: sales@aircrafthardwareacces.com

Packing Slip

ATTN: Shipping Dept.

Date: 10/10/2018

TO: DART AEROSPACE

1270 ABERDEEN STREET

Hawkesbury ON K6A1K7

Packer # 101018

Cust. PO #: 41285

Qty	Tool #	REF#	Description
1	RBT1015771		STAKING TOOL

DA.
38
9-88

ALL MATERIALS, PARTS OR COMPONENTS HAVE BEEN INSPECTED
AND COMPLY WITH THE PURCHASE ORDER REQUIREMENTS